

Work Order ID 76960

76960

Page 1

Thursday, November 24, 2011 12:42:59 PM

Item ID: D350-636-011

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 11/24/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/1/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

MLT 11-12-28

76960

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

MO 11-11-25

B 11/12/05

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11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left
 from bending as per QSI 004
 A/R Aluminum Rod batch: m118735 BE11-12-05

12-Grind welds flush as per Dwg D2750 BB 11/12/05

120 QC10- Inspect visual per QSI004- ground welds 0.00
120
 QC Memo 0.00
 Quality Control

S u12/05

130 QC5- Inspect part completeness to step on W/O 0.00
130
 QC Memo 0.00
 Quality Control

S u12/05

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Run Start *NR1*

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

①

SAD 11-12-05

DP

11-12-5

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 045 A/R Sikaflex-291 batch: 114399 exp. date: 12/08/13								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: M118735								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

SAD
11-12-05

BT 11-12-09

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1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

8/11-12-09

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

8/11-12-09

②

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	CE/BL	11-12-14	
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:15								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 2:45								
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

IXD m 11/12/14

1 BL 11-12-22

m 11/9/480

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	HandFinishing					1	BR	11-12-22	
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
230		0.00							
230	HandFinishing					1	BR	11-12-22	
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>n/a</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>119443</u>								
	EXP DATE: <u>12-1</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>110348</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>114596</u>								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
250 *250* Packaging Packaging	Pick Kit Memo	0.00 0.00							
260 *260* QC Quality Control	QC4- 100% Inspect kits for completeness Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00							

Dart Aerospace Ltd

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011	0.00							
280		0.00							
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

U 11.12.28

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Picklist Print

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:ec
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1		Manufactured	No			230	Each	46.0000	8	8			
D3492-1									**				
Plug	<i>* D3492-041</i>				<i>70185.</i>					<i>8.</i>		<i>BR 11-12-22</i>	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP				46					
					69531			8					
					74444			38					
D3492-3		Manufactured	No			230	Each	89.0000	8	8			
D3492-3									**				
Plug												<i>BR 11-12-22</i>	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP				45					
					74447			45					
				FP-B				44					
					74871 ✓			44		<i>8.</i>			

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Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

235.0000

8

8

NAS1611-010

O-RING

**

BL 11-12-22

Location

Loc Qty

Loc Code

FP

235

110915

14

117460

8

118077

1

118612

3

119438

159

119623 ✓

50

NAS1149D0863J

Purchased

No

250

Each

208.0000

2

NAS1149D0863.J

WASHER

**

8/2

11/12/28

Location

Loc Qty

Loc Code

ST298

208

118078

108

119307

100

D2744

Manufactured

No

110

Each

47.0000

1

1

D2744

Cap

**

BE11-12-05

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

34

71861

34

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Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each

22.0000

1 1

D2600-3-BENT

**

Extrusion Bent

Location

Loc Qty

Loc Code

LG

22

66875

8

73253

1

75021

4

75022

8

75023

1

①

MO

11-11-25

D2743

Manufactured No

160 Each

279.0000

8 8

D2743

**

Crossbolt Spacer

BE 11-12-07

Location

Loc Qty

Loc Code

LG

269

71839

5

73403

64

74445

100

76141

100

8

LG001

10

67766

4

68251

6

D2739

Manufactured No

160 Each

14.0000

1 1

D2739

**

350 I Beam

BE 11-12-05

B76967

Location

Loc Qty

Loc Code

LG

14

72155

1

76140

6

76866

4

76867

3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

Thursday, November 24, 2011 12:43:03 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160 Each

74.0000 .4 4

D3490-3

Cross Bolt Spacer

**

BE 11-12-07

Location	Loc Qty	Loc Code
LG	34	
76234	34	2
LG001	40	
74877	40	2

D3490-1 Manufactured No

160 Each

114.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE 11-12-07

Location	Loc Qty	Loc Code
LG	8	
67773	5	
71841	3	
LG001	106	
62450	2	
74875	64	4
76233	40	

ALS4-1032-225 Purchased No

220 Each

1,885.000 38 38

ALS4-1032-225

Insert

**

BR 11-12-22

Location	Loc Qty	Loc Code
ST281	1885	
108696	281	
110768	62	
118386	858	38.
118966	684	

Thursday, November 24, 2011 12:43:03 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 12:43:03 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-3 Manufactured No

230 Each

24.0000 1 1

D3793-3

Wearshoe

**

BL 11-12-22.

Location

Loc Qty

Loc Code

FP001

24

74528 ✓

8

74593

4

75043

12

1

AN8C35A

Purchased No

230 Each

99.0000 1 1

AN8C35A

BOLT

**

BL 11-12-22.

Location

Loc Qty

Loc Code

FP

65

115960

1

118286

64

ST345

33

117834 ✓

33

ST346

1

114442

0

115188

0

115960

1

1

D3793-1 Manufactured No

230 Each

20.0000 1 1

D3793-1

Wearshoe

**

BL 11-12-22

Location

Loc Qty

Loc Code

FP001

12

75038 ✓

12

FP018

8

74591

8

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 12:43:04 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

23.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

Bl 11-12-22

Location

Loc Qty

Loc Code

FG008

11

75056

11

FP

4

69903

4

FP007

1

61689

1

FP008

7

67788

1

71887 ✓

6

D3794-3

Manufactured No

230

Each

23.0000

1

1

D3794-3

Gasket

**

Bl 11-12-22

Location

Loc Qty

Loc Code

FP002

23

74530

9

74596 ✓

14

AN6C44A

Purchased No

230

Each

107.0000

4

4

AN6C44A

BOLT

**

Bl 11-12-22

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

105

118985 ✓

40

119125

30

119530

35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 12:43:04 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

100.0000

1

1

MS21083C8

**

Bl 11-12-22

NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

98

115884

0

118614 ✓

37

119309

11

119436

25

119638

25

D3536-25

Manufactured

No

230

Each

31.0000

1

1

D3536-25

**

Bl 11-12-22

Gasket

Location

Loc Qty

Loc Code

FP012

31

74595 ✓

5

75039 ✓

26

D3631-1

Manufactured

No

230

Each

495.0000

8

8

D3631-1

**

Bl 11-12-22

Washer

Location

Loc Qty

Loc Code

ST072

495

68062 ✓

10

75548 ✓

485

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 12:43:04 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 31.0000 1 1

D3791-1

Wearplate

**

BL 11-12-22

Location	Loc Qty	Loc Code
FP002	16	
75041	16	
FP017	15	
62239	2	
74527	1	
74598 ✓	12	

AN960C10L ~~✗~~ NAS1149C0332 R Purchased No

***AN960C10I ***

washer

D2745 Manufactured No 230 Each 133.0000 8 8

D2745

Bushing

**

BL 11-12-22

**

BL 11-12-22

Location	Loc Qty	Loc Code
FP	76142.	73
69529	1	
74446	72	
ST021	60	
71835	60	

8.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 12:43:04 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 797.0000 34 34

AN3C5A

Bolt

**

PL 11-12-22

Location	Loc Qty	Loc Code
FP 119749	7	34.
115835	7	
ST350	790	
116419	28	
117343	17	
117764	52	
117872	2	
118451	191	
119127	500	

D3537-1 Manufactured No 230 Each 42.0000 3 3

D3537-1

Wearpad

**

PL 11-12-22

Location	Loc Qty	Loc Code
FP002 74867	35	3.
74436	30	
74597	5	
FP017	7	
69817	5	
70686	2	

NAS1149C0832R Purchased No 230 Each 331.0000 1 1

NAS1149C0832R

WASHER

**

PL 11-12-22

Location	Loc Qty	Loc Code
FP-B	3	1
114915	3	
ST297	328	
114915	328	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 12:43:04 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No

230

Each

252.0000

4

4

AN3C6A

BOLT

**

BL 11-12-22

Location

Loc Qty

Loc Code

FP

119749
111982

1

1

ST350

100

119449

100

ST351

151

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

96

4.

NAS1611-013

Purchased

No

230

Each

196.0000

8

8

NAS1611-013

O-RING

**

BL 11-12-22

Location

Loc Qty

Loc Code

FP

196

116582

5

117291

2

117887

53

119307

76

119438

10

119623

50

8.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 12:43:04 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230 Each

28.0000 1 1

D3535-25

Wearshoe

**

BL 11-12-22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	18	
74525	6	
75040	12	
FP018	10	
62233	1	
74592 ✓	9	<i>1</i>

D3794-1

Manufactured No

230 Each

41.0000 1 1

D3794-1

Gasket

**

BL 11-12-22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP014	41	
74529	1	
74594 ✓	12	<i>1</i>
75042	28	

MS21043-6

Purchased No

230 Each

449.0000 4 4

MS21043-6

NUT

**

BL 11-12-22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
103693	20	
ST300	429	
112314 ✓	219	<i>4.</i>
117887	10	
118384	200	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 12:43:04 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

61.0000

2

**

D3493-1

Washer

Location

Loc Qty

Loc Code

ST062

61

70697

4

71846

27

76237

30

MS21083C8

Purchased

No

250

Each

100.0000

2

**

MS21083C8

NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

98

115884

0

118614

37

119309

11

119436

25

119638

25

AN8C21A

Purchased

No

250

Each

71.0000

2

**

AN8C21A

BOLT

Location

Loc Qty

Loc Code

ST343

71

118045

11

118758

30

119530

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 12:43:04 PM

Work Order ID: 76960

76960

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

155.0000

4

4

***NAS1515H3I ***

WASHER

**

BL 11-12-22

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

115

113362

11

118686

4

119438 ✓

100

D2741

Manufactured

No

250

Each

3.0000

1

1

D2741

Blade, 350 Skidtube

**

B71856

Location

Loc Qty

Loc Code

ST466

3

70667

3

D3532-1

Manufactured

No

250

Each

46.0000

2

2

D3532-1

Spacer

**

11/2/25

Location

Loc Qty

Loc Code

ST065

46

73342

6

74880

40

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16960

RELEASED
68 07 17 16

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA		
DRAWN	PA		
CHECKED	PA		
MFG. APPR.	PA		
APPROVED	PA		
DE APPR.	PA		
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F SHEET 1 OF 11	
TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS	
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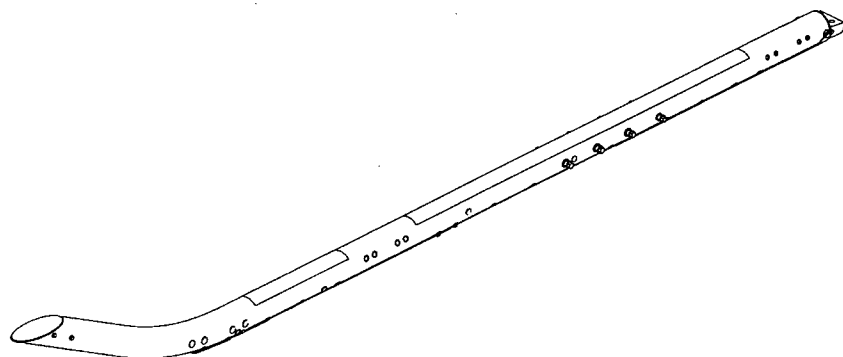
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

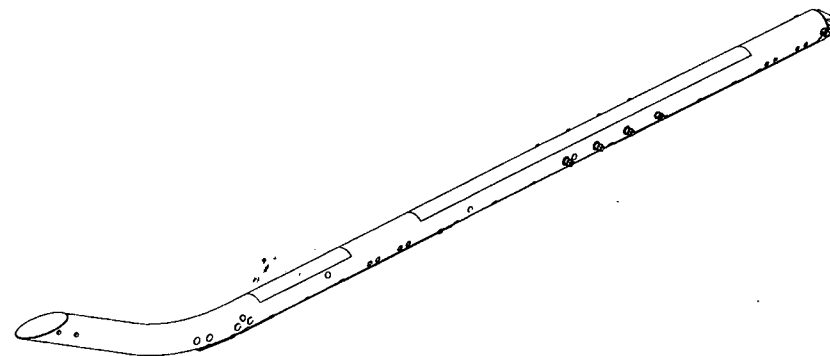
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



76960

D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
28-9-22 AM

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	LM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	SA	D2750	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
DE APPR.	SA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

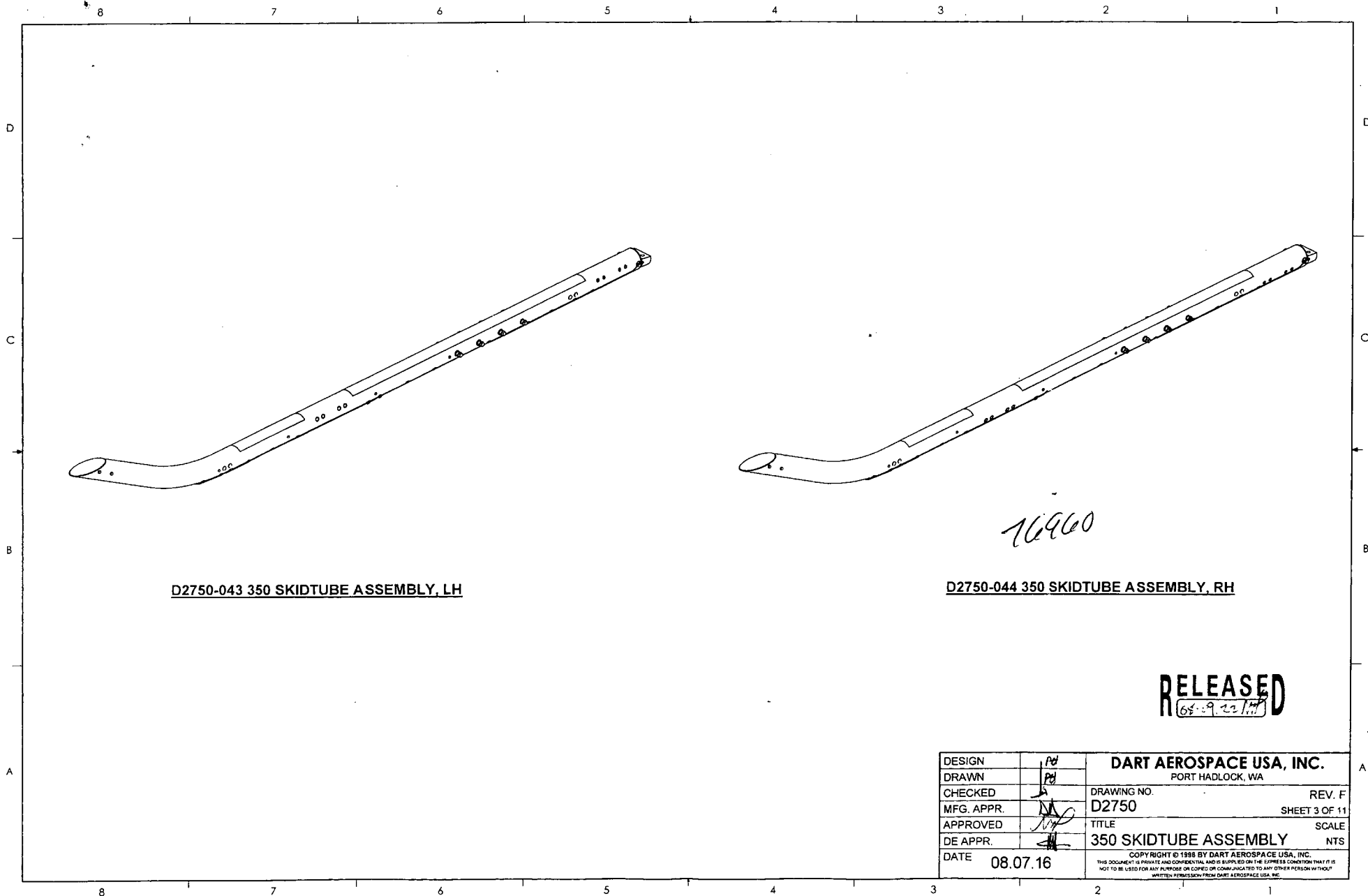
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



76960

RELEASED
68-09-22/117

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	NA	DRAWING NO.	REV. F
MFGR. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
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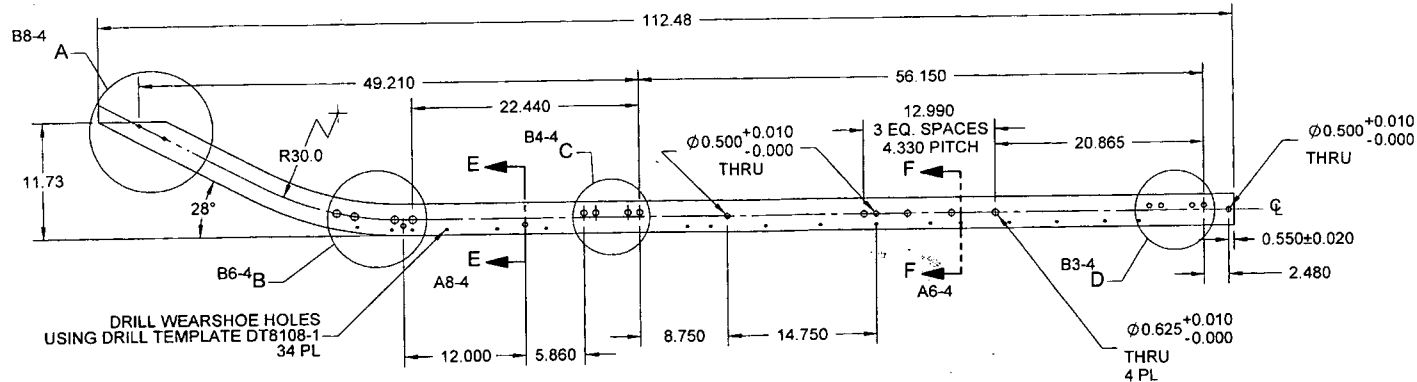
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

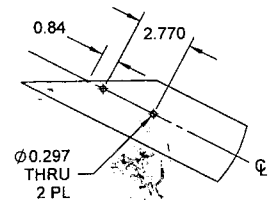
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

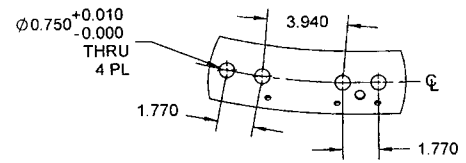


D2750-1 LH SKIDTUBE

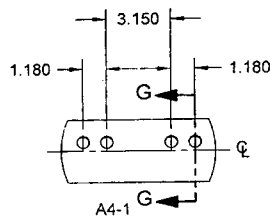
76960



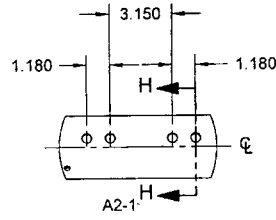
DETAIL A
SCALE 2X



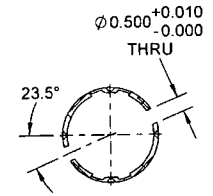
DETAIL B
SCALE 2X



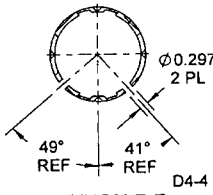
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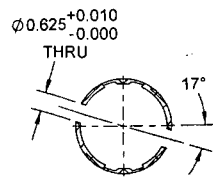
DETAIL D
SCALE 2X



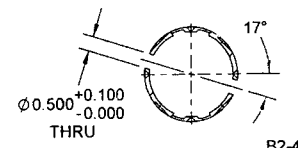
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

DESIGN	IP	DART AEROSPACE USA, INC.	
DRAWN	RU	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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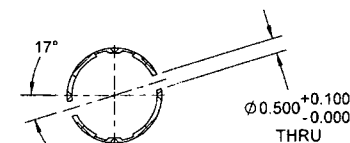
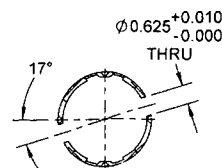
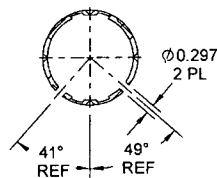
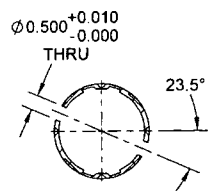
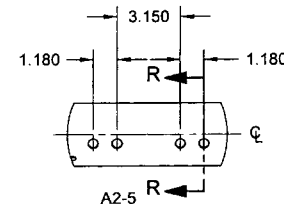
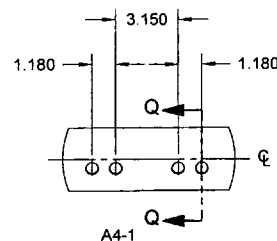
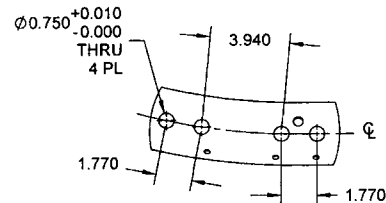
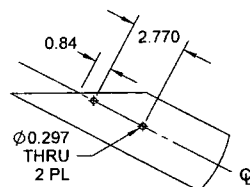
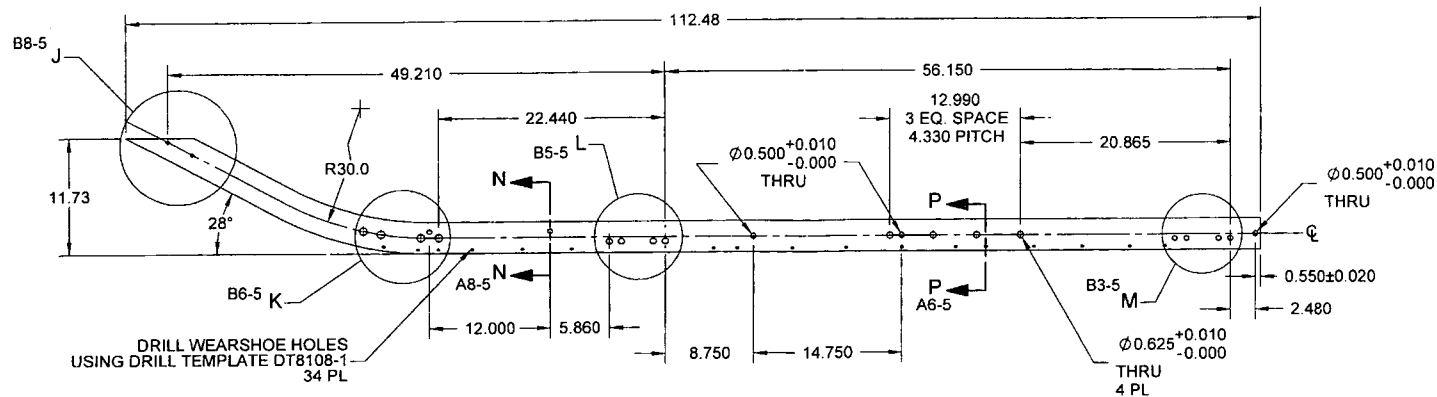
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
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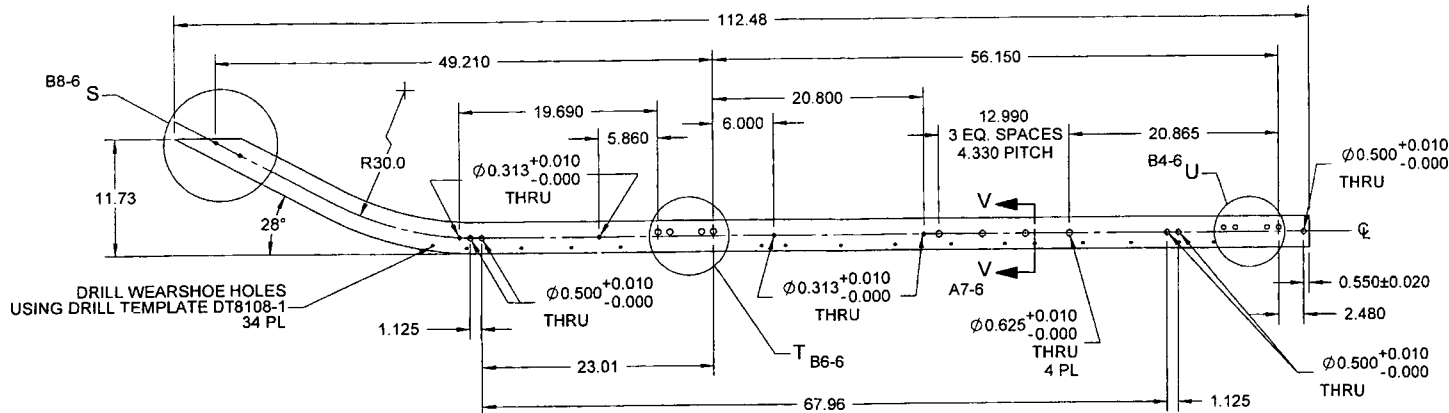
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

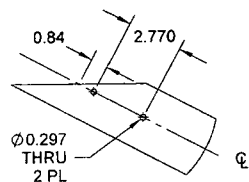
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

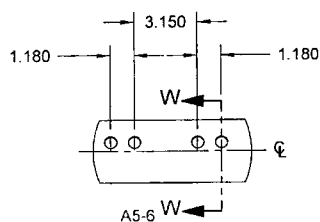
NOTE: Date & initial all entries



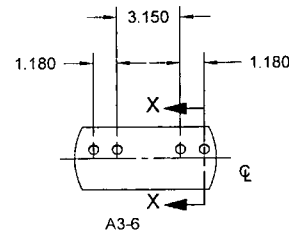
D2750-3 LH SKIDTUBE



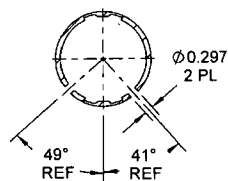
DETAIL S
D8-6
SCALE 2X



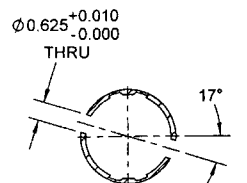
DETAIL T
C5-6
SCALE 2X



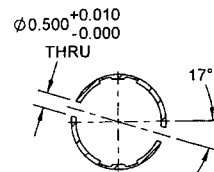
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



SECTION X-X
B4-6
SCALE 3X, 4 PL

RELEASED
08-22-11

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
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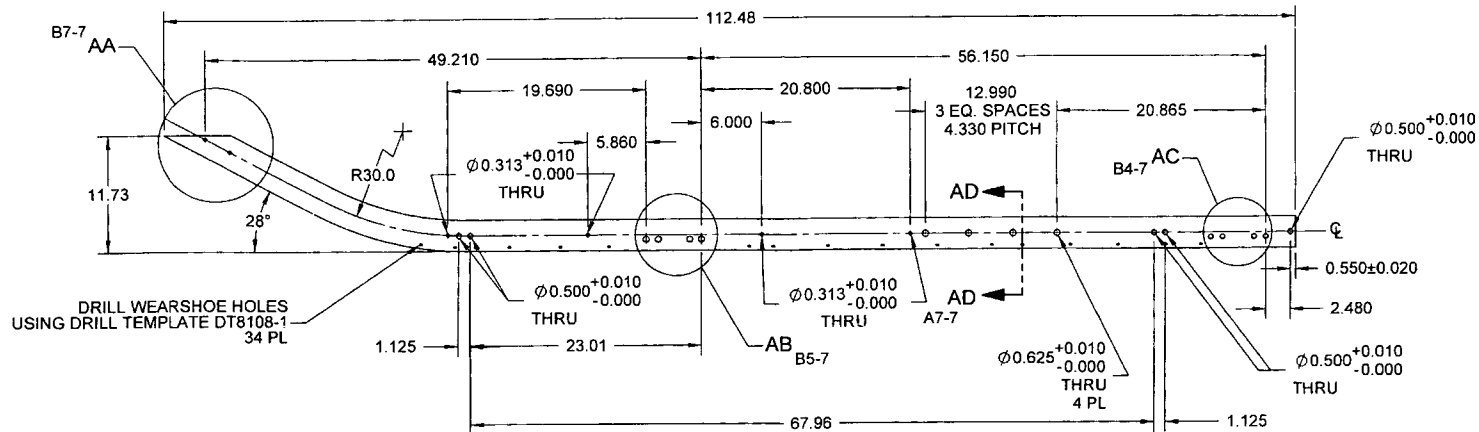
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

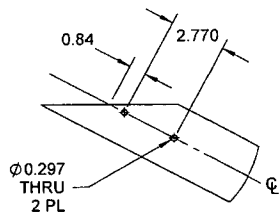
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

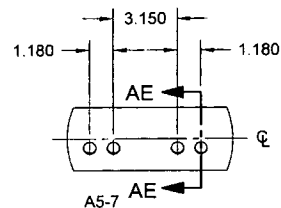
NOTE: Date & initial all entries



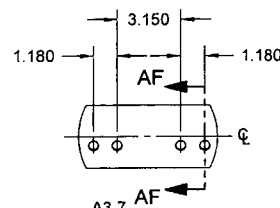
D2750-4 RH SKIDTUBE



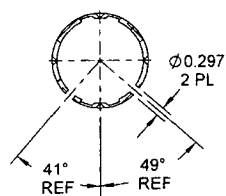
DETAIL AA
SCALE 2X



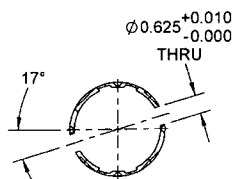
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SCALE 2X



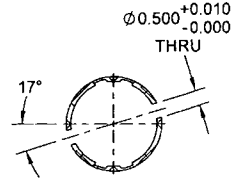
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

76960

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DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED	REV	DRAWING NO. D2750	REV. F
MFG. APPR.	REV	TITLE	SHEET 7 OF 11
APPROVED	REV	350 SKIDTUBE ASSEMBLY	
DE APPR.	REV	SCALE	
DATE	08.07.16	NTS	

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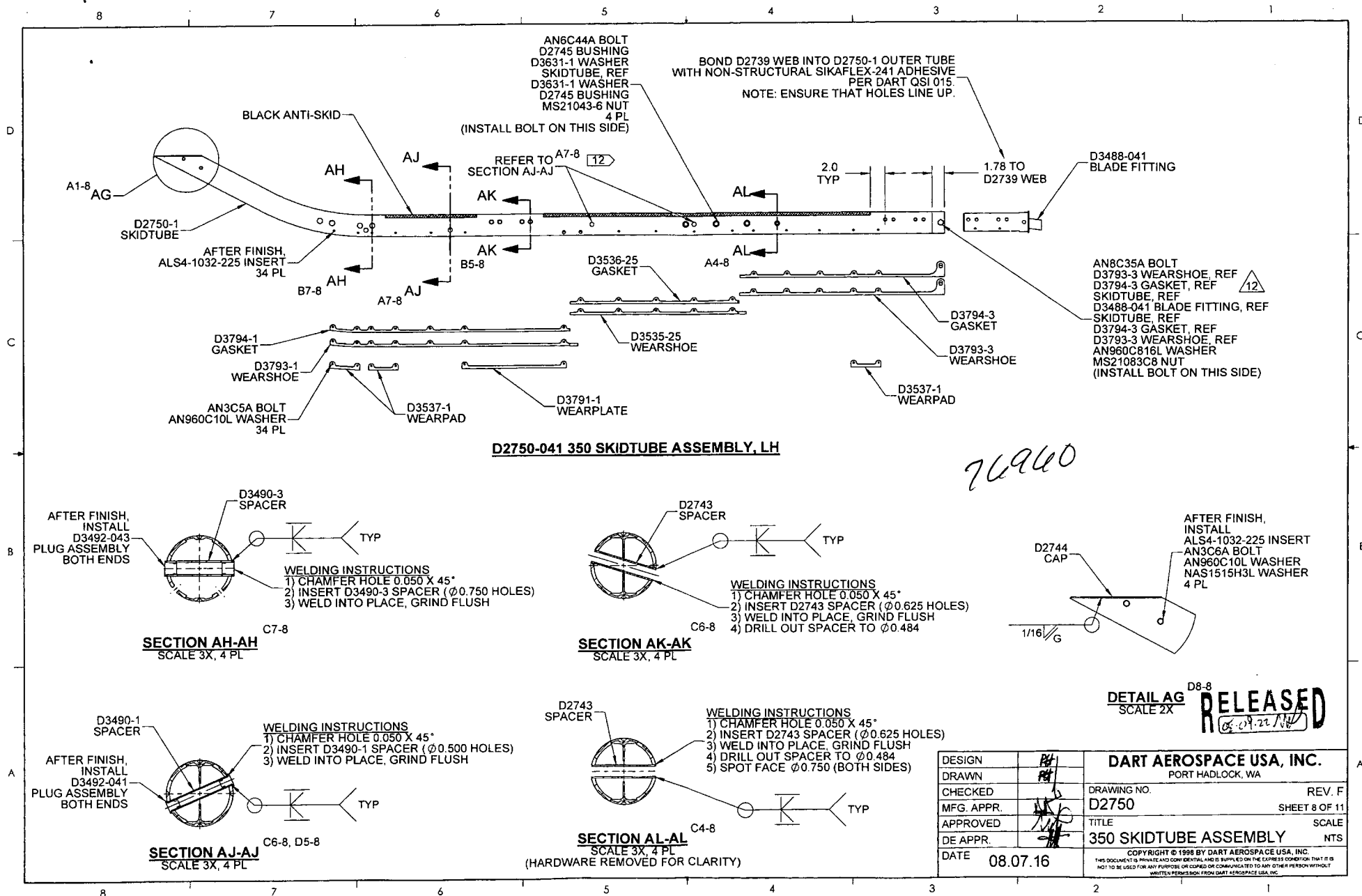
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D

C

B

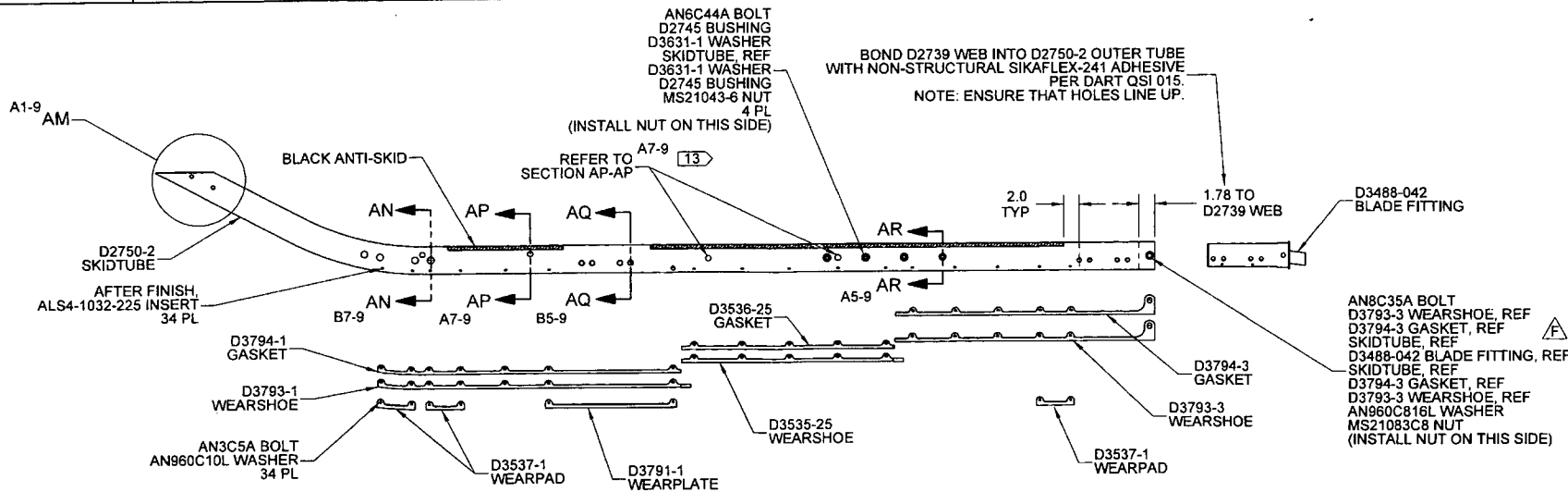
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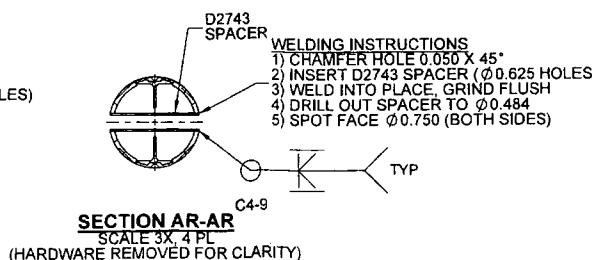
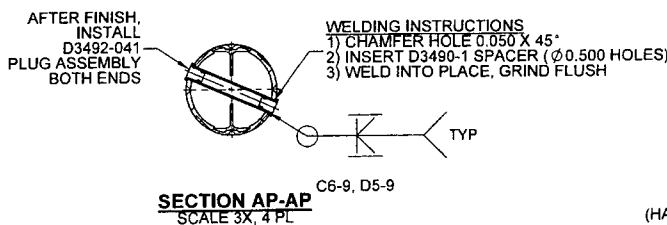
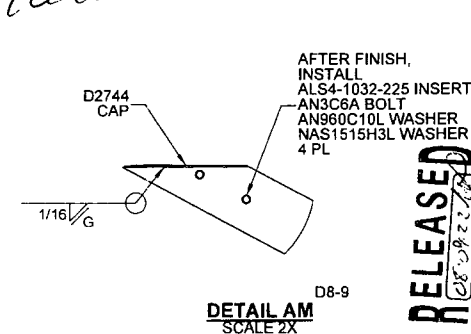
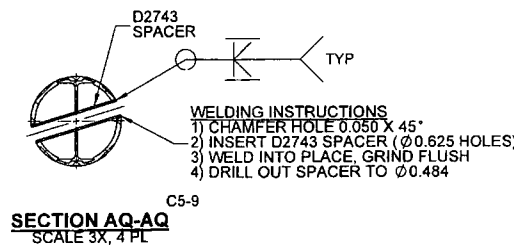
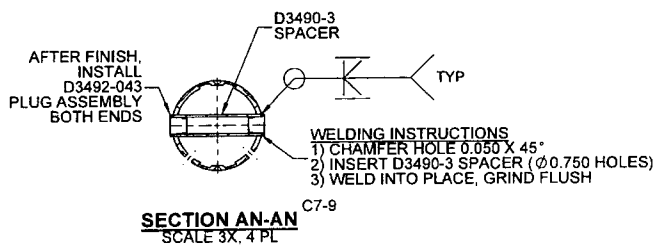
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B

A



D2750-042 350 SKIDTUBE ASSEMBLY, RH



DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO. D2750	REV. F
MFG. APPR.	MD		SHEET 9 OF 11
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08-09-22-18

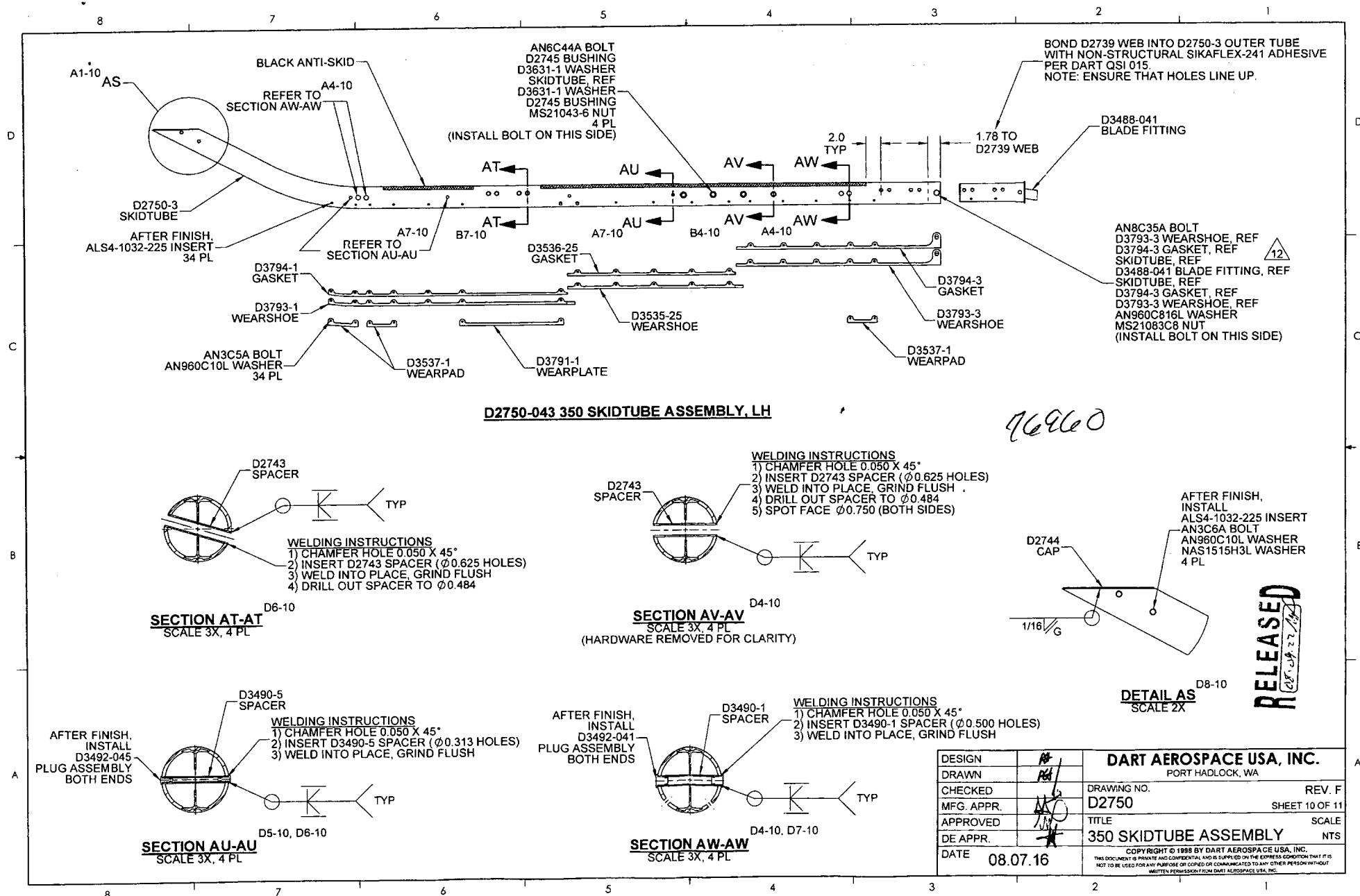
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector




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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG APPR.		D2750	SHEET 10 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

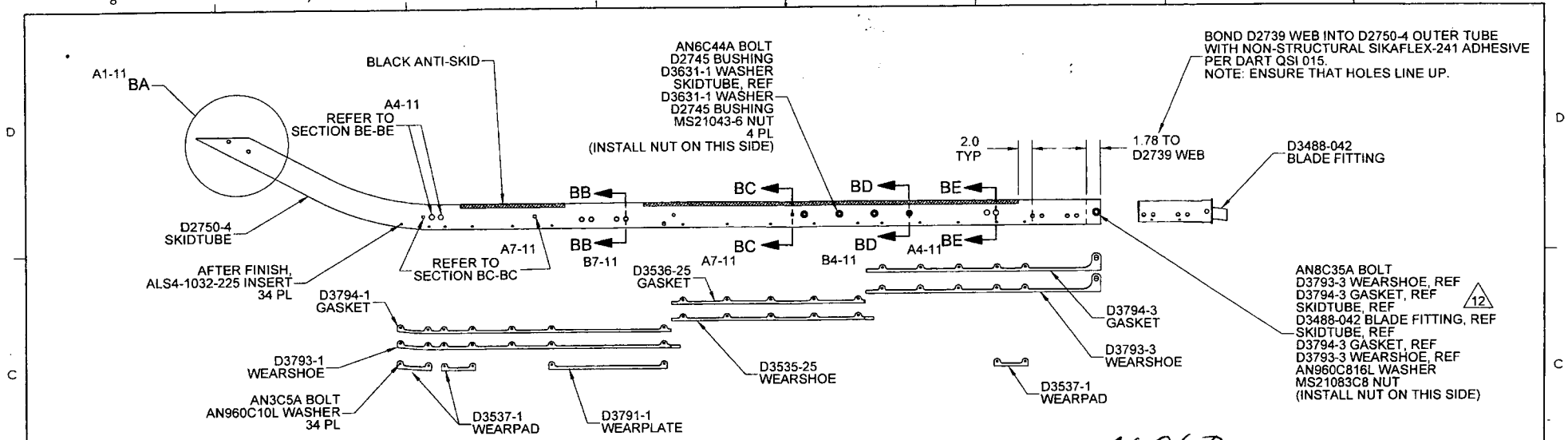
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

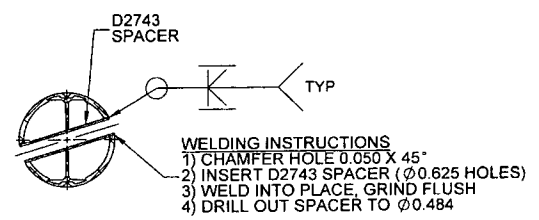
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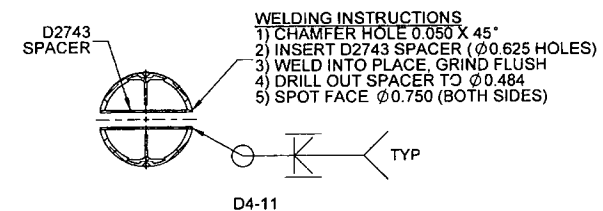
D2750-044 350 SKIDTUBE ASSEMBLY, RH

26960

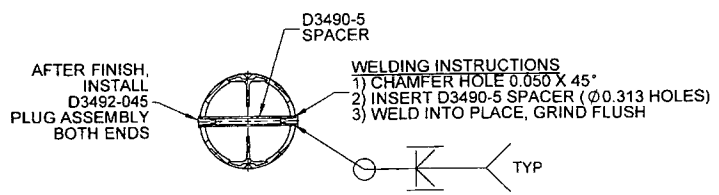
RELEASED
08-07-22 / W/P



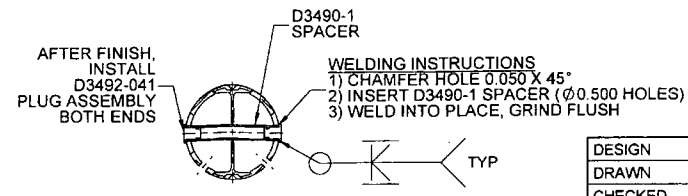
SECTION BB-BB
SCALE 3X, 4 PL



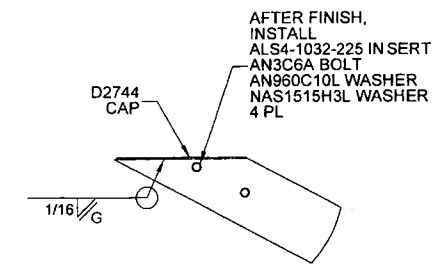
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 276

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 75349
Part number: 350-636-011
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Paul Date of Test Coupon 11.11.22

Welder Barclay Elliot Date of Test Coupon 11.11.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld